

Work Order ID 66577

Tuesday, February 22, 2011 11:09:06 AM

Page 1

Item ID: D3255-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Access Panel Assembly

Start Date: 2/23/2011 Start Qty: 2.00

Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *11-02-22* Tooling:

Date:

Run Start

QC:

Date: SPC (Y/N):

Date:

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld as per Dwg D3255 ***purge weld*** A/R SS ROD
Batch: *M/15778* □2-Grind Welds Flush

11.06.07 ②

110

0.00



QC10- Inspect visual per QSI004- ground welds

QC

Memo

0.00

Quality Control

S u l o c l o g

②

042

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

S u l o c l o g

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66577

Tuesday, February 22, 2011 11:09:06 AM



Page 2

Item ID: D3255-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Access Panel Assembly

Start Date: 2/23/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 3/9/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set-Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

FINISH TIME:

OVEN TEMPERATURE:

0.00

Powder Coating

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg
D3255 A/R 736 DOW CORNING ADHESIVE
Batch: 111664

SB 1166/09

2x ~~Q~~ M-L 11/06/08

2 ~~Q~~ BR 11-6-8.

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			






NOTE: Date & initial all entries



Work Order ID 66577



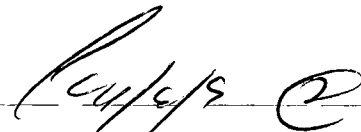


Tuesday, February 22, 2011 11:09:06 AM



Page 3

Item ID: D3255-042 Accept  Setup Start 
Revision ID: Stop 
Item Name: Access Panel Assembly
Start Date: 2/23/2011 Start Qty: 2.00  Cust Item ID:
Required Date: 3/9/2011 Req'd Qty: 2.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		8/106/10		(2) -042			
170  Packaging Packaging	Identify as per dwg & Stock Location: _____ Memo PM 69192	0.00 0.00							11/6/13 
180  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							11/6/13  MF 11-06-10

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Picklist Print

Tuesday, February 22, 2011 11:09:03 AM

Page 1

Work Order ID: 66577

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly




Start Date: 2/23/2011

Required Date: 3/9/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3255-2  Panel		Manufactured	No			100	Each	1.0000	1	(2)		11.06.07	
B69054													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				1					
				61686				1					
D3255-3  Cap		Manufactured	No			150	Each	6.0000	1	(2)		11.06.07	
B66812													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				WA				2					
				48315				2					
				WA21				4					
				63587				4					
D3255-5  Gasket		Manufactured	No			100	Each	5.0000	1	2		11.06.07	
B63703													
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST044				5					
				63588				5					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

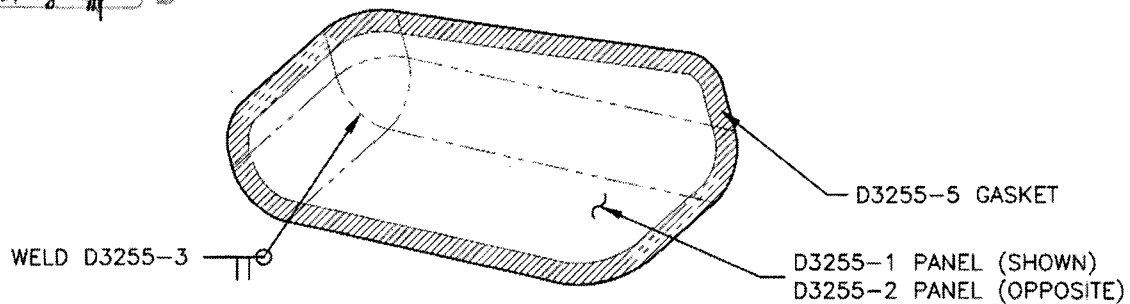
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

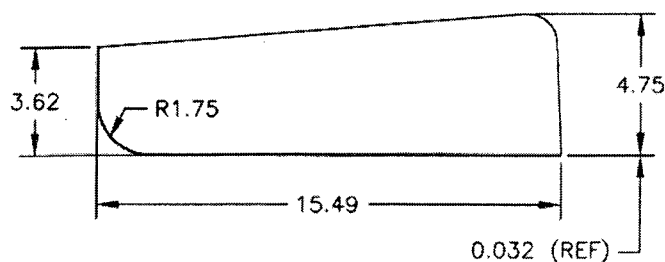
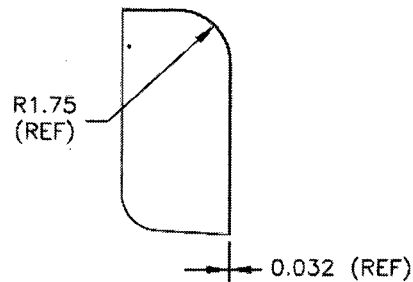
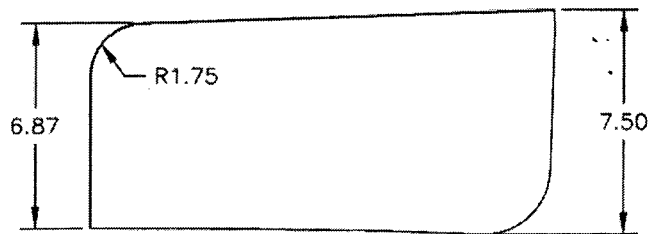


DESIGN TF	DRAWN BY TF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 4P	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

#66577

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DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

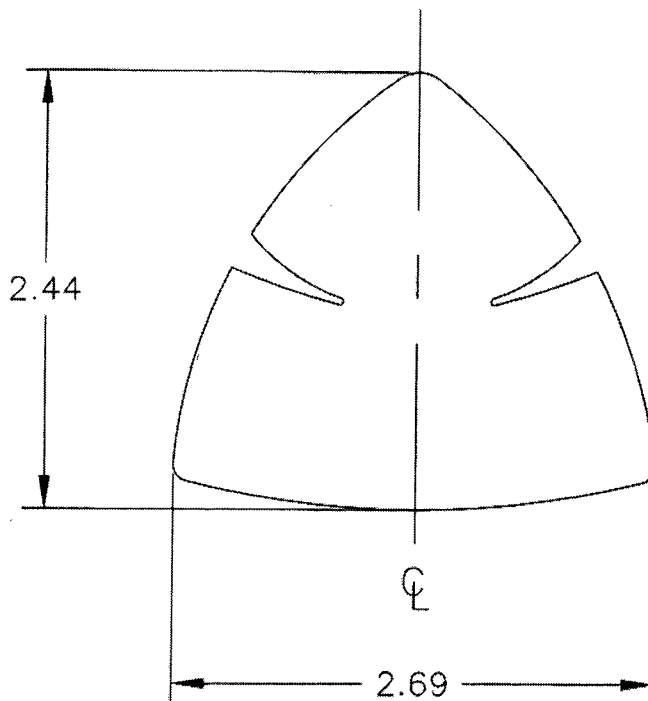
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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN DF	DRAWN BY DF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 91	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.08 [Signature]



D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

#66577

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

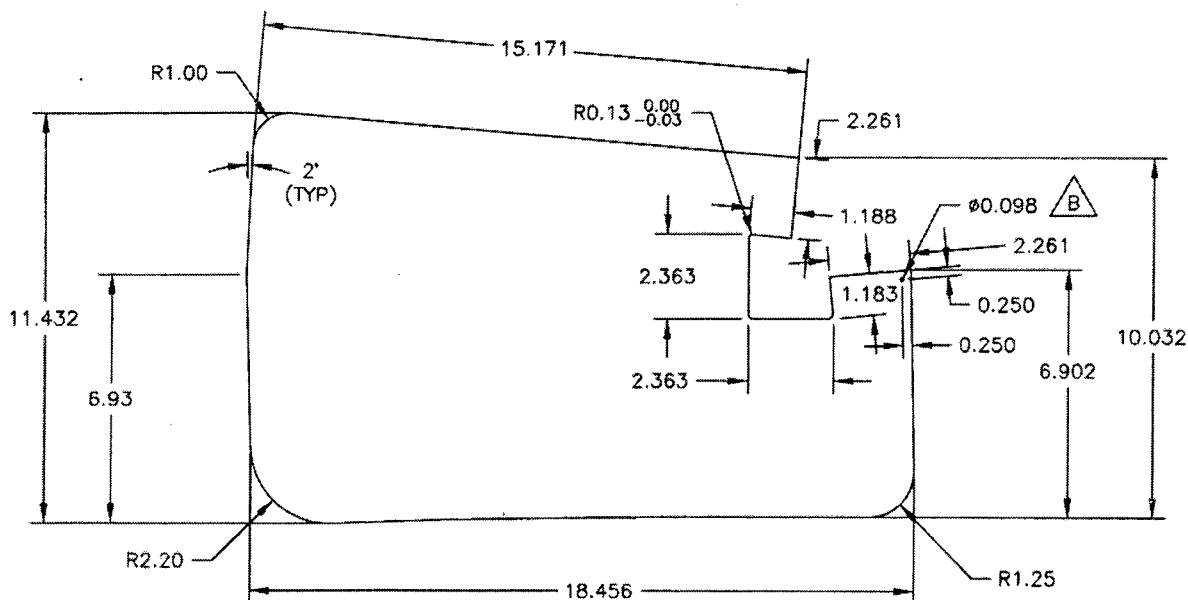
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P	APPROVED H	DRAWING NO. D3255	REV. B SHEET 3 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
05-01-18



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

#66577

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

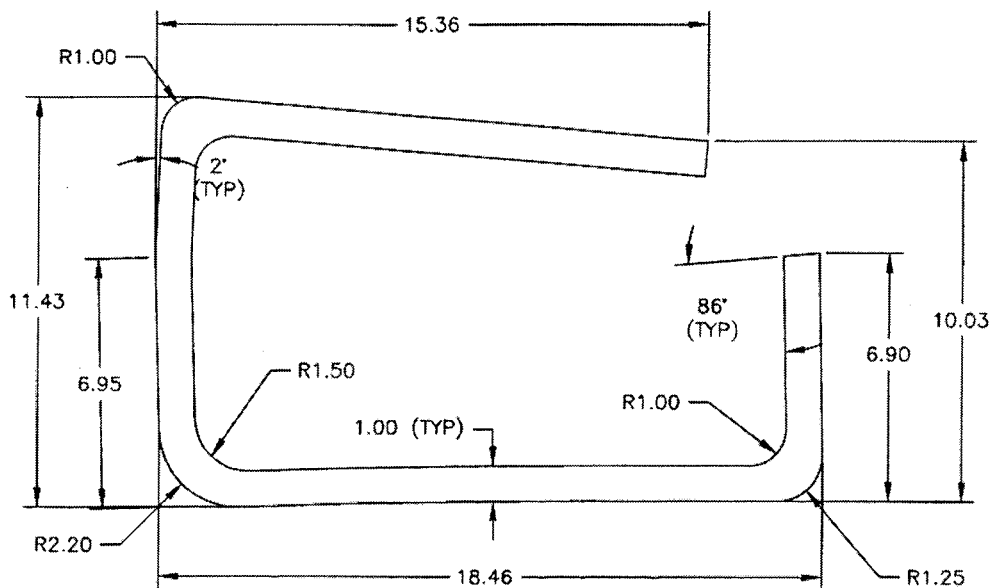
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
DS 01.18 JH



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries